

Date: Wednesday, 15/11/2006 7:48:36 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 29455	Part Number	: D2596
Estimate Number	: 10346	Drawing Number	: D2596 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 15/11/2006 S.O. No. : 516	Drawing Revision	: C
Prsh Rev.	: NC	Material	: N/A
First Issue	: N/A Type : LANDING GEAR	Due Date	: 22/11/2006 Qty: 20 Um: Each
Previous Run	: 28652		
Written By	:		
Checked & Approved By	:		
Comment	: Est: 99.02.02 Changed QA to QC, Added Step 6 and Cost D M		

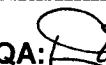
Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n 'I' Beam Web 4"	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Extrusion "I" Beam Web 4"	(20)
		Pick: Qty Part Number Description Batch	m.b 06/11/15
	1 D2500-3-100 Extrusion	325751	
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.625" diameter using a uni-bit 4- Deburr m.b 06/11/15	m.b 06/11/15 (20) m.b 06/11/15 (20) m.b 06/11/15 (20) 06/11/16 (20)
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1	m.b 06/11/16 (20)
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	D 0-11-20 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/11/2006 7:48:36 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 29455

Part Number: D2596

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6

DP 6-11-20

6.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

(20)
6-11-20

Job Completion



6-11-20

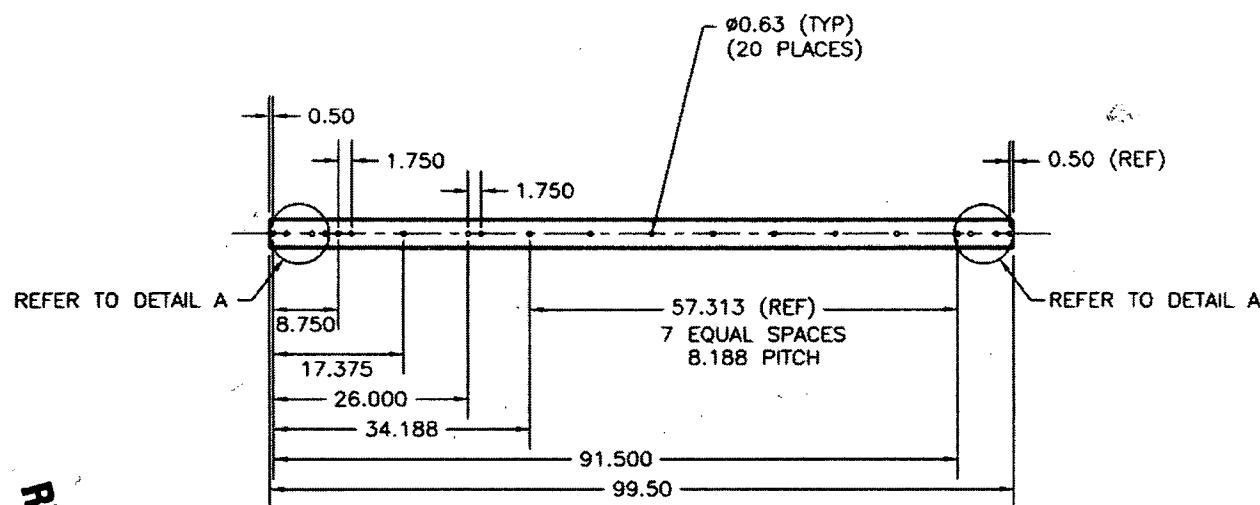
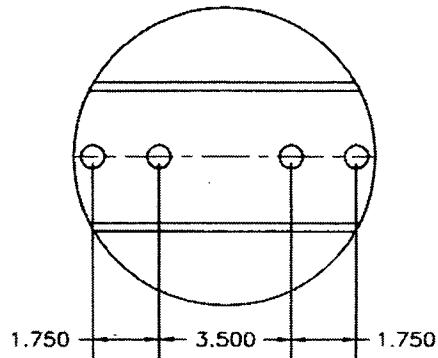
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A
SCALE 5:24



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

RELEASED
[48.09.17 DS]

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD		
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA	
DATE		D2596	REV. C	
A	96.09.16	205 WEB	TITLE	SHEET 1 OF 1
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	Ø0.63	SCALE 1:24
C	98.09.14	INCORPORATED DEO 9097		